

Wbrk Order ID 140825

140825

Page 1

Tuesday, January 19, 2016 2:43:51 PM

Item ID: D212-580-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dual Cargo Mirror Installation

Start Date: 1/19/2016 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 1/19/2016 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: MLS Date: JAN 19 2016

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2161	B2
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IIN-D212-580-1	B
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MLS

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D212-580-041 CHG004

APR 07 2016

GAS
27
9-89MLS 16-03-31
(9)

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

4 MLS

MAR 31 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐							

DQA: _____ Date: _____



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Work Order update only ☐

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		OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 140825

140825

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 1/19/2016

Required Date: 1/19/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM
IPP REV:I AS PER ECN10-611 10-09-07 JLM VERIFIED
BY:DD IPP rev:J
10.11.22 AS PER ECN10-642 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3439-101		Manufactured	No			100	Each	16.0000	2	8			

D3439-101

Mirror Assembly 8"

**

MAR 31 2016

Location	Loc Qty	Loc Code
FG	2	
103697	2	
ST383	14	
125449	14	

DAS
27
9-89

D2161-212

Manufactured No

100 Each 0.0000

D2161-212

Mirror Bracket, 212"

**

MAR 31 2016

MS20426AD3-4

Purchased No

100 Each 2,922.000

MS20426AD3-4

RIVET

**

MAR 31 2016

Location	Loc Qty	Loc Code
GA	2811	
m131697	2811	
ST312	111	
m127432	111	

DAS
27
9-89

32

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Tuesday, January 19, 2016 2:43:54 PM

Page 2

Work Order ID: 140825

140825

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 1/19/2016

Required Date: 1/19/2016

Start Qty: 4.00

Required Qty: 4.00

D4164-041

Manufactured No

100

Each

46.0000

4

16

D4164-041

Nut Plate Adapter Assembly

**

MLJ

MAR 31 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST090A

15

129429

15

~~ST096~~

31

St CSS

118921

25

123400

6

16

MS27039-1-08

Purchased

No

100

Each

451.0000

4

16

MS27039-1-08

Screw

**

MLJ

MAR 31 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

275

m128636

275

GA

2

125654

2

ST281

78

m128636

78

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

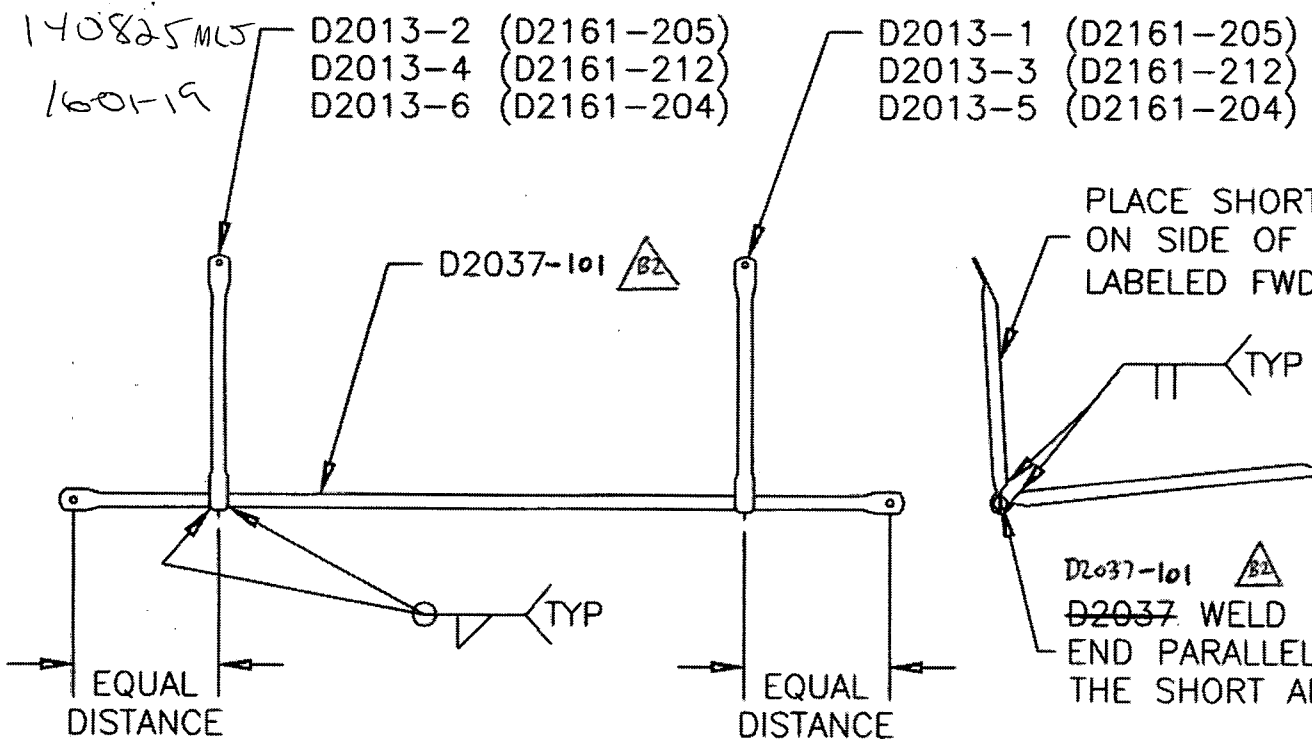
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			



DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED RT	DRAWING NO. D2161
DATE 99.06.07	TITLE MIRROR BRACKET	REV. B SHEET 1 OF 1
A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 WELD



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~ B1

RELEASED
H KE 99.06.10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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		OTHER : ☐							

4.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

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Date: 12.06.13

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